



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 66372**

Friday, February 11, 2011 2:00:31 PM



Page 2

Item ID: D2842-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Assembly, 206 Float

Start Date: 2/14/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 2/28/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

3

Ø

BE 11/02/28

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 11/02/28

X364

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

S 11-03-03

3

Ø

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# Work Order ID 66372

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Page 3

Item ID: D2842-041

Accept



Setup Start



Revision ID:

Item Name: Step Assembly, 206 Float

Stop



Start Date: 2/14/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 2/28/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7m-k 11/03/03

30

170

Weld per dwg A/R Aluminum rod Batch M102436 0.00

Large Fab

0.00

Large Fab

Memo

1-Remove alodine prior to welding.  
Weld end cap as per Dwg D2842.  
2-Grind end cap weld flush.

Large Fab

11.03.04

3

φ

180

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

11/03/07

43

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Work Order ID 66372

Friday, February 11, 2011 2:00:31 PM



Page 5

Item ID: D2842-041	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Step Assembly, 206 Float					
Start Date: 2/14/2011	Start Qty: 3.00		Cust Item ID:		
Required Date: 2/28/2011	Req'd Qty: 3.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				3	6	11/03/09	
220  HandFinish Hand Finishing	HandFinishing  Memo 1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: 11116702	0.00  0.00		=> .yd		3	9	11/03/11	
230  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		S 11/03/11		x3 44			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 66372**

Friday, February 11, 2011 2:00:31 PM



Page 6

Item ID: D2842-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Assembly, 206 Float

Start Date: 2/14/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 2/28/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

240

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

AP  
66318

11/3/14

5/30

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/15  
MF  
11-03-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Friday, February 11, 2011 2:00:26 PM

Page 1

Work Order ID: 66372

Parent Item: D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 2/14/2011

Required Date: 2/28/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM□□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960C10L	NAS1149C0332 R	Purchased	No			100	Each	25.0000	3	9			

  
washer

X1116304

 (y9) JH n/03/09

## Location

## Loc Qty

## Loc Code

ST245

25

107534

25

D2622-120C

Manufactured

No

120

Each

111.6440

1

3



Step Extrusion



11.02.22

## Location

## Loc Qty

## Loc Code

WA

111.644

55214

1.92

58544

1

61208

4.724

64409

104

D2734

Manufactured

No

120

Each

43.0000

2

6



Step End Plate



11.02.24

## Location

## Loc Qty

## Loc Code

WA

43

62931

43

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Friday, February 11, 2011 2:00:26 PM

Page 2

Work Order ID: 66372

Parent Item: D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 2/14/2011

Required Date: 2/28/2011

Start Qty: 3.00

Required Qty: 3.00

D3459-1 Manufactured No

220

Each

41.0000

2

6



Float Step Mounting Plate



*HL 11.02.23*

Location

Loc Qty

Loc Code

WA

41

61213

10

62955

31

*4*  
*2*

D3459-3 Manufactured No

120

Each

45.0000

2

6



Float Step Mounting Plate



*HL 11.02.23*

Location

Loc Qty

Loc Code

WA

45

62396

14

62956

31

*6*

MS27039C1-07 Purchased No

220

Each

43.0000

3

9



screw



*HL 11/03/09*

Location

Loc Qty

Loc Code

ST293

43

111424

3

115460

40

*X9*

NAS1329C3KB130 Purchased No

220

Each

52.0000

3

9



insert



*HL 11/03/09*

Location

Loc Qty

Loc Code

ST276

52

111981

6

115719

46

*X9*

Friday, February 11, 2011 2:00:27 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Friday, February 11, 2011 2:00:27 PM

Page 3

Work Order ID: 66372

Parent Item: D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 2/14/2011

Required Date: 2/28/2011

Start Qty: 3.00

Required Qty: 3.00

NAS1515H3L

Purchased

No

220

Each

308.0000

3



9  
22 4/03/11

WASHER

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

268

111819

34

113362

234

x9

Friday, February 11, 2011 2:00:27 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

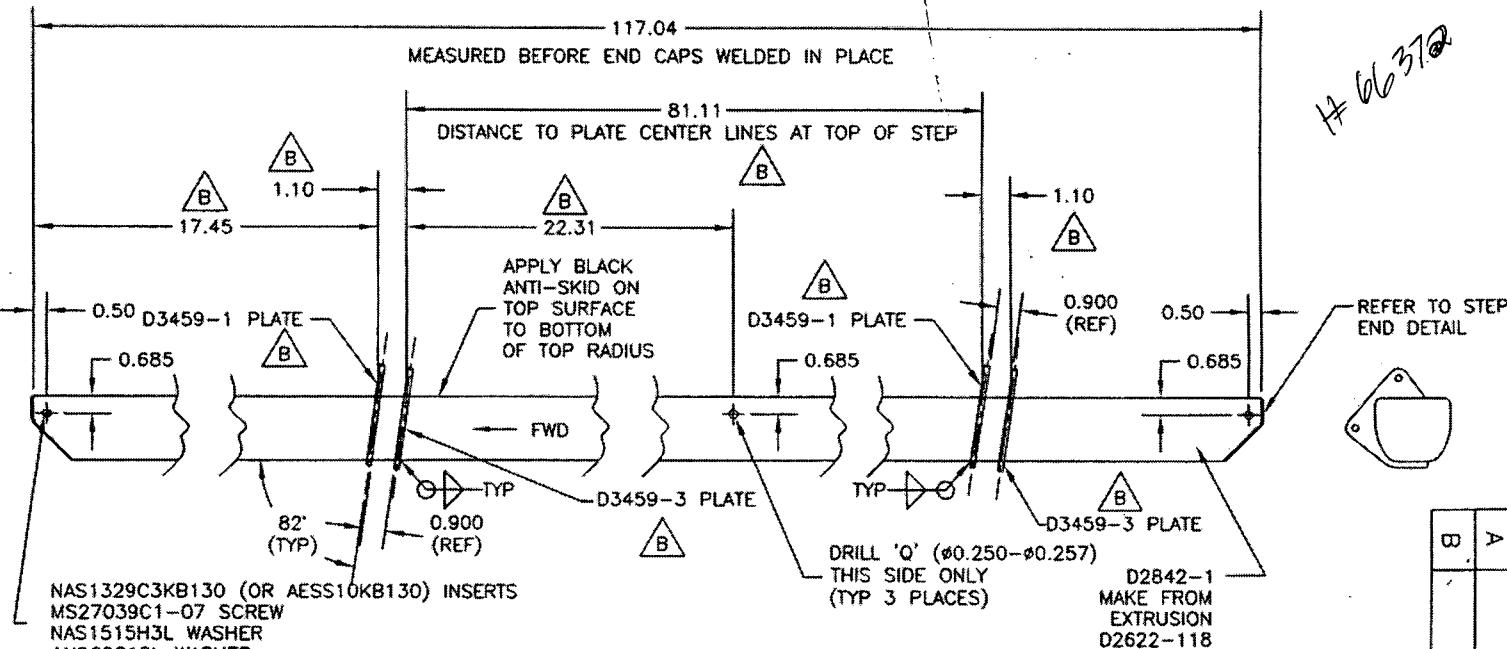
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**DART**

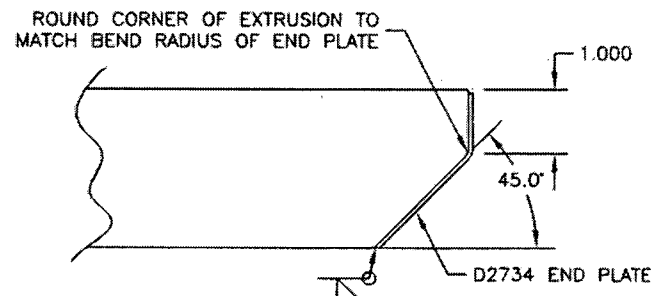
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
KE	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
DATE	DATE	D2842
05.09.23	98.10.13	206L/407 FLOAT STEP ASSEMBLY
A	NEW ISSUE	SHEET 1 OF 1
B	RE-DESIGN, ADD D3459-1/-3	SCALE
		NTS



**D2842-041 LH STEP ASSEMBLY (SHOWN)  
D2842-042 RH STEP ASSEMBLY (OPPOSITE)**

**D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST**

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X	X	D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER



**TYPICAL STEP END DETAIL  
NOT TO SCALE**

**D2842-041/-042 FLOAT STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
5-11-14

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